

between the workpieces based upon the control information for each workpiece.

16. The method of claim 15 further comprising the steps of:

- 5 (a) sensing one or more of the position, velocity and acceleration of a workpiece as the workpiece is fed or transported downstream to the planer and collecting corresponding data therefrom; and
- (b) controlling the acceleration of each workpiece to establish and/or control and/or correct a minimum required optimized gap between the workpieces.

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17. The method of claim 15 further comprising the steps of

- (a) determining in-piece gap-reduction for a successive series of workpieces in the array of workpieces, wherein said means for setting the size of gaps between successive workpieces cooperates with said means for determining in-piece gap-reduction so as to reduce said size of gaps, and
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- (b) determining a corresponding optimized planing solution for a downstream workpiece in said successive series of workpieces thereby providing for in-piece setting of the cutting elements within said downstream workpiece so as to pre-
- 20 position the cutting elements for commencing an optimized planing solution for a next adjacent upstream workpiece in said successive series of workpieces, whereby said size of gap between said downstream and upstream workpieces is reduced.